

Fig. 1

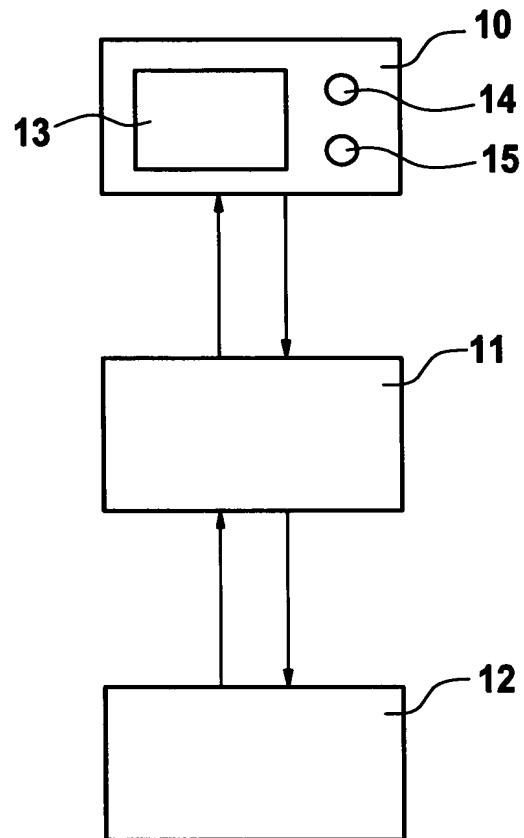


Fig. 2

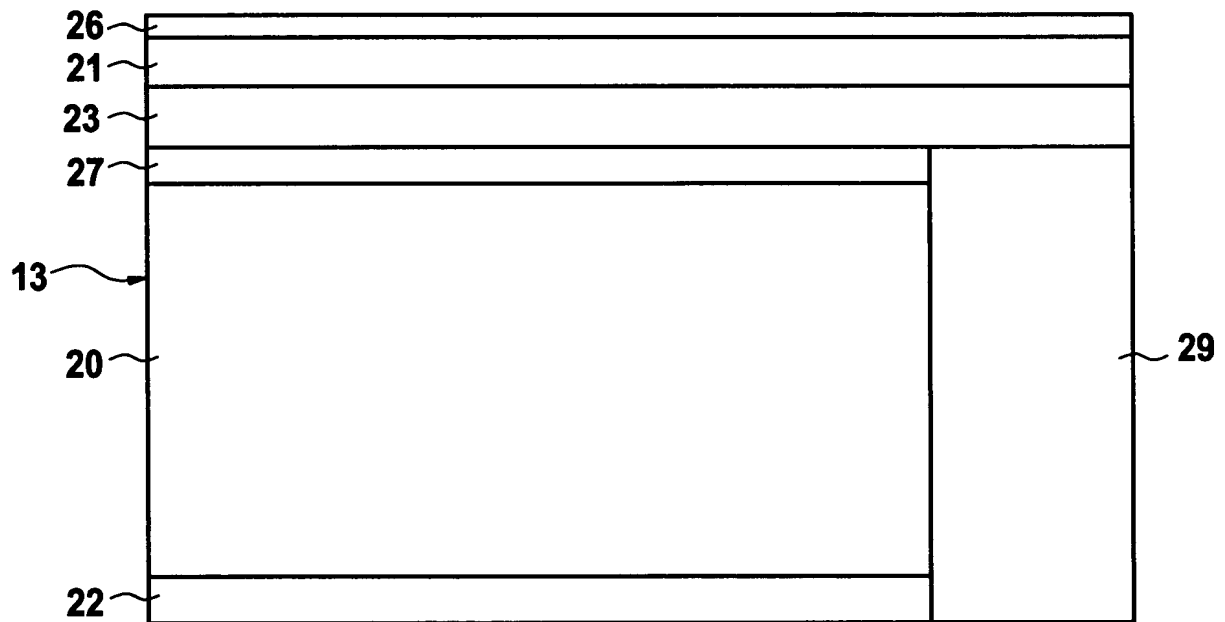


Fig. 3

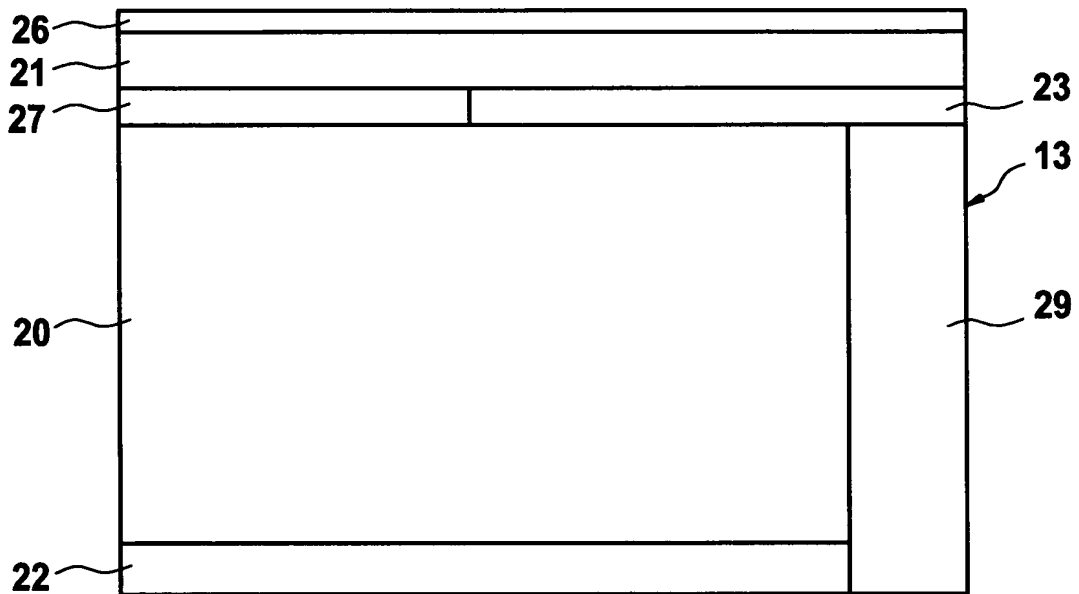


Fig. 4

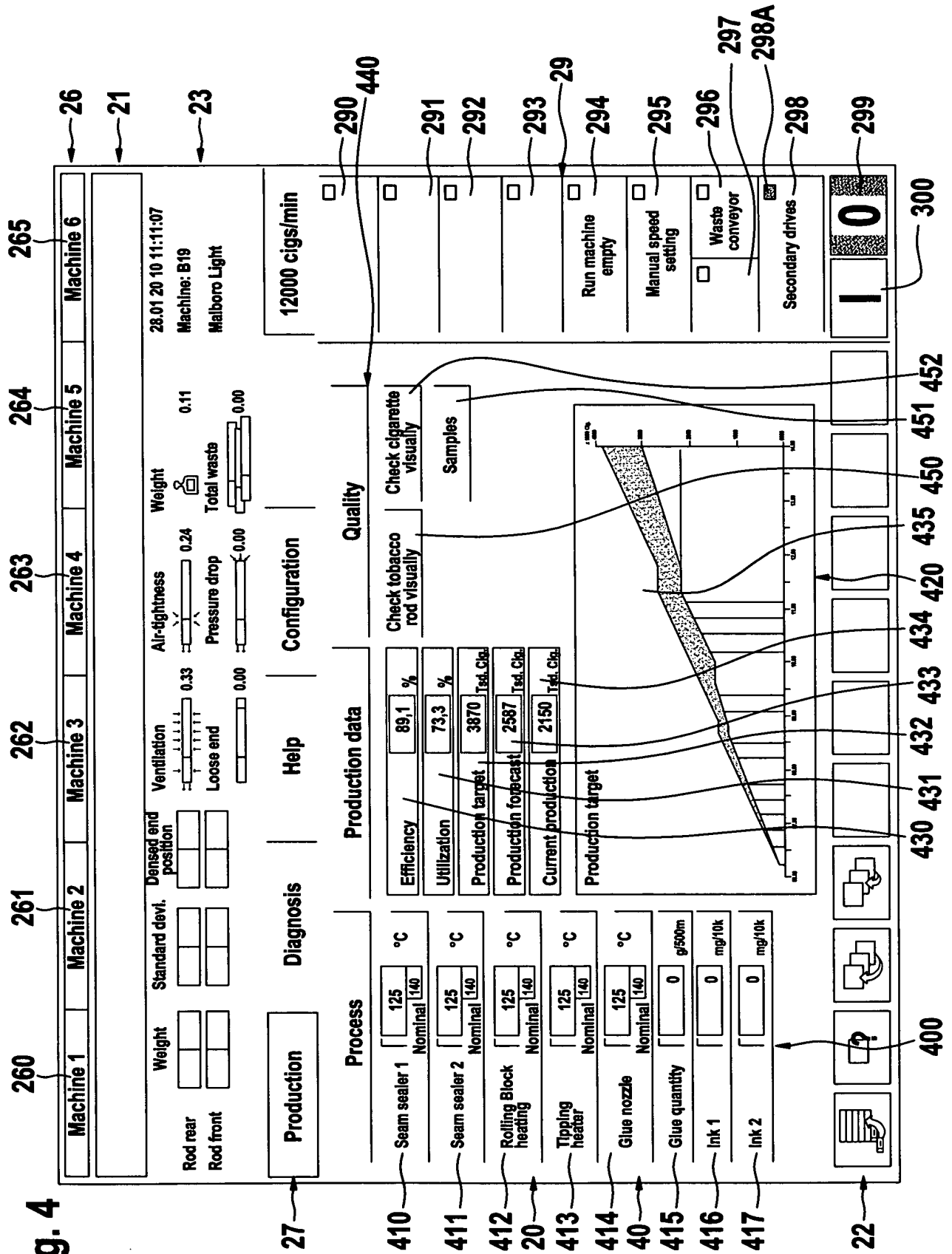


Fig. 5

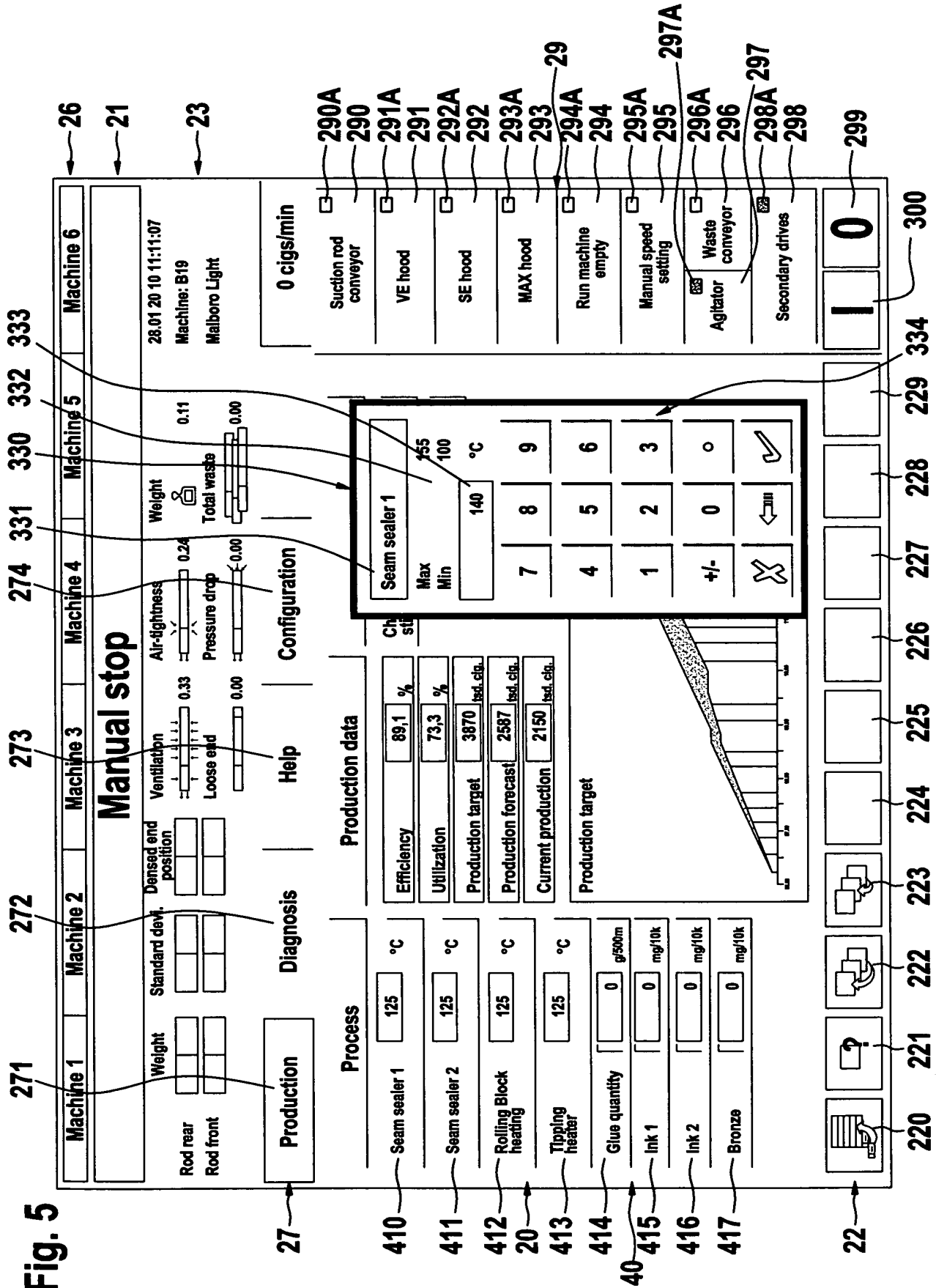


Fig. 6

Machine 1
Machine 2
Machine 3
Machine 4
Machine 5
Machine 6

SE bobbin

Weight:

Rod rear:

Rod front:

28.01 20 10 11:11:07

Machine: B19

Malboro Light

Ventilation: 0.33

Loose end: 0.00

Air-tightness: 0.24

Pressure drop: 0.00

Weight: 0.11

Total waste: 0.00

Production

Seam sealer 1: 125 °C

Seam sealer 2: 125 °C

Rolling Block heating: 125 °C

Tipping heater: 125 °C

Glue quantity: 0 g/500m

Ink 1: 0 mg/10k

Ink 2: 0 mg/10k

Bronze: 0 mg/10k

Diagnosis

Efficiency: 89,1 %

Utilization: 73,3 %

Production target: 3870 /std. cig.

Production forecast: 2587 /std. cig.

Current production: 2150 /std. cig.

Help

Production data

Production target: ?

Configuration

Quality

0 cigs/min

Suction rod conveyor: ☐

VE hood: ☐

SE hood: ☐

MAX hood: ☐

Run machine empty: ☐

Manual speed setting: ☐

Agitator conveyor: ☐

Waste conveyor: ☐

Secondary drives: ☐

Production target

220

221

222

223

224

225

226

227

228

229

Check tobacco rod visually

Check cigarette visually

220

221

222

223

224

225

226

227

228

229

220

221

222

223

224

225

226

227

228

229

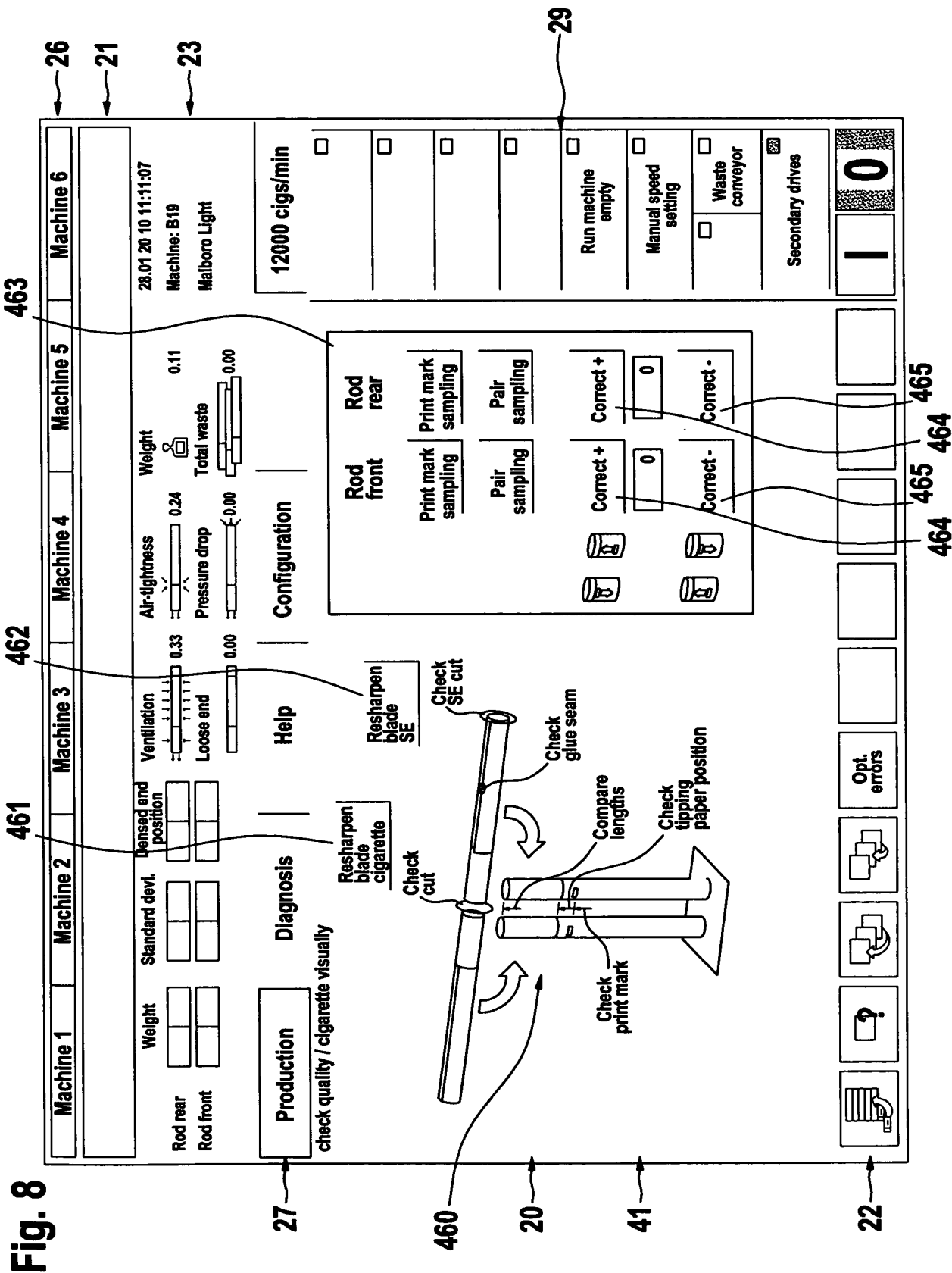


Fig. 9

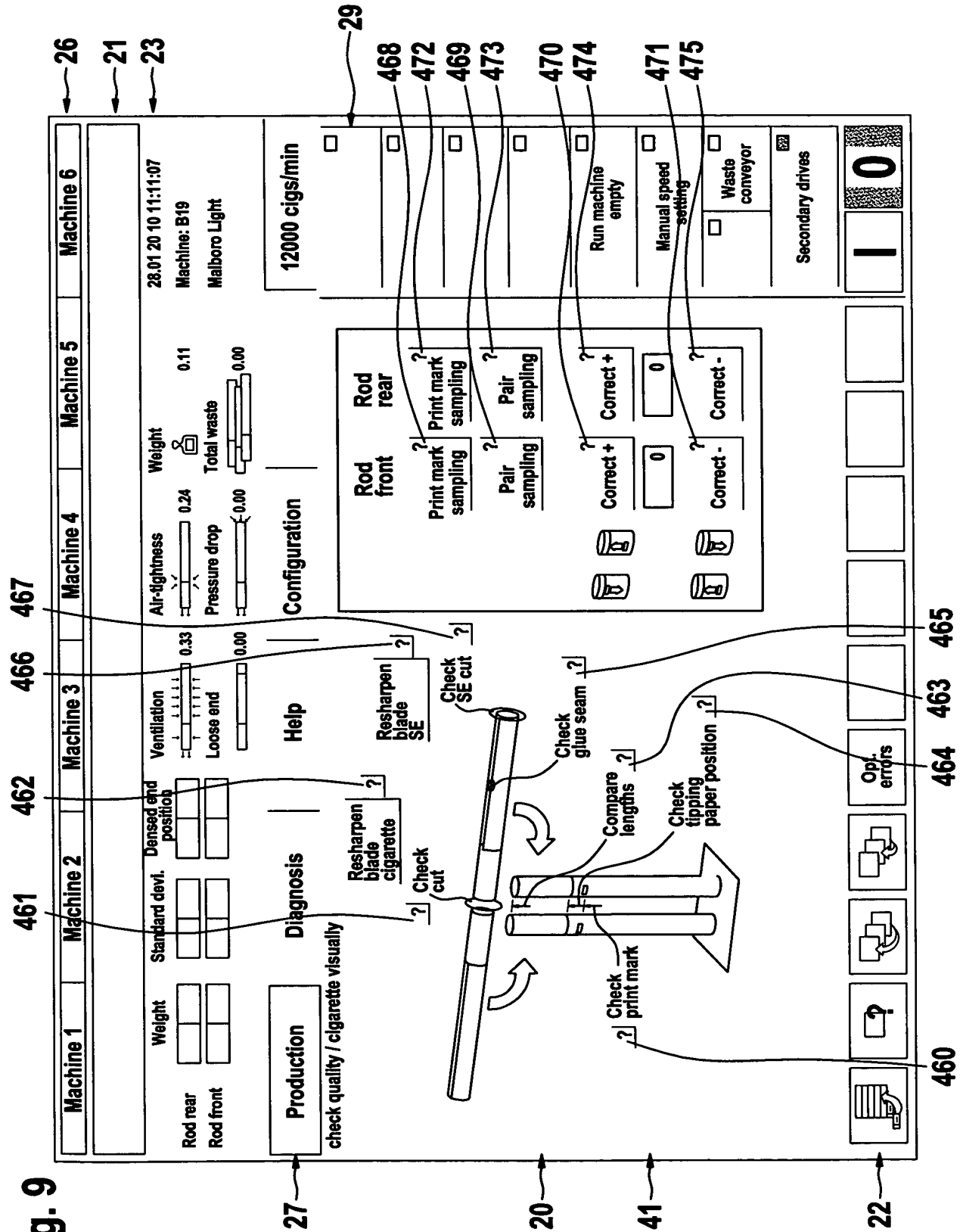


Fig. 10

Machine 1
Machine 2
Machine 3
Machine 4
Machine 5
Machine 6

26
21
23

28.01 20 10 11:11:07
 Machine: B19
 Marlboro Light

12000 cigs/min

Weight: 0.11
 Air-tightness: 0.24
 Ventilation: 0.33
 Pressure drop: 0.00
 Total waste: 0.00

27

Production

check quality / cigarette visually

Configuration

Resharpen blade cigarette ?

Blade

Rod front ? Print mark sampling ? Pair sampling ? Correct + ? Correct - ?

Rod rear ? Print mark sampling ? Pair sampling ? Correct + ? Correct - ?

Run machine empty

Manual speed setting

Waste conveyor

Secondary drives

1 0

20

41

22

480

Opt. errors

Help view ▶ End

Fig. 11

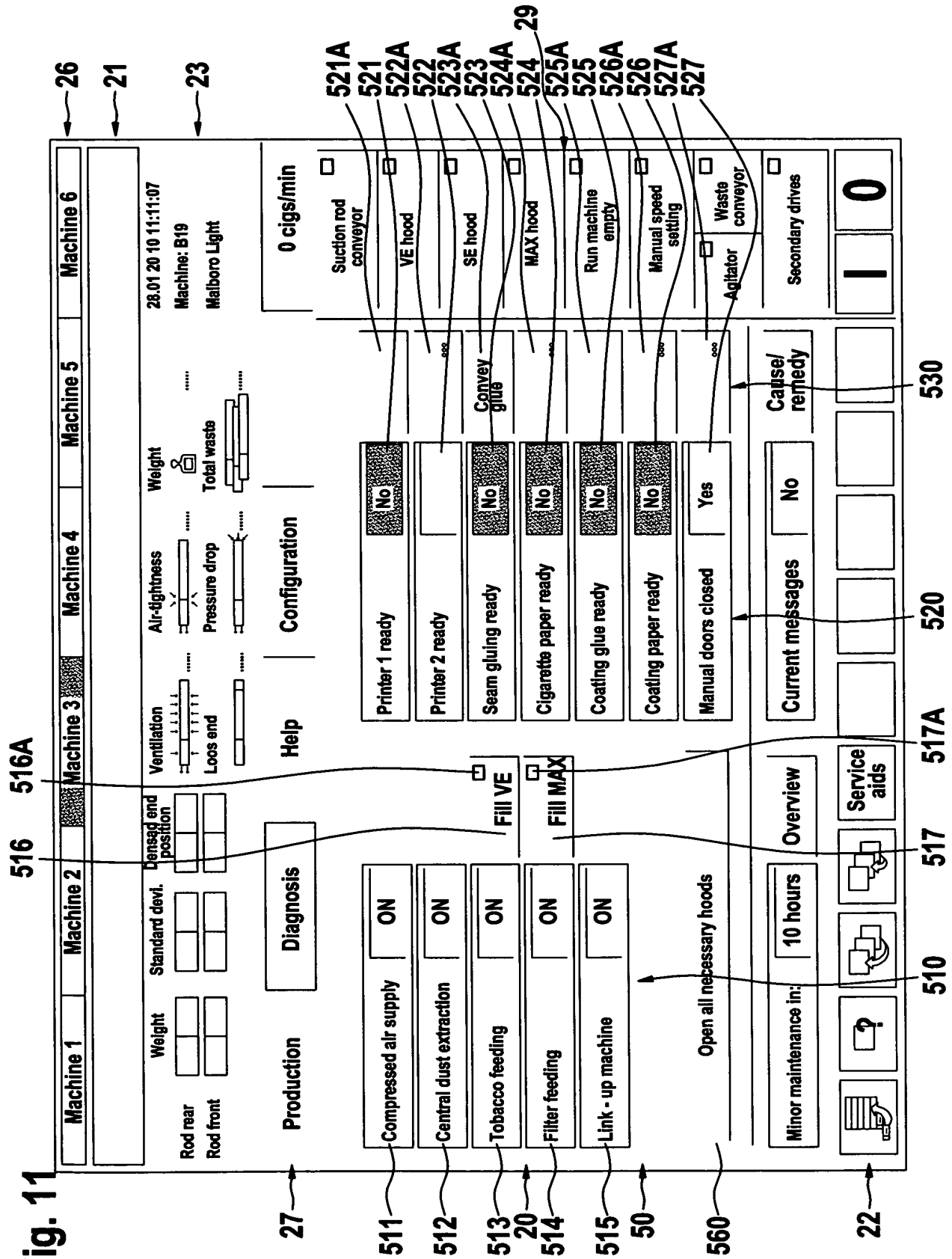


Fig. 12

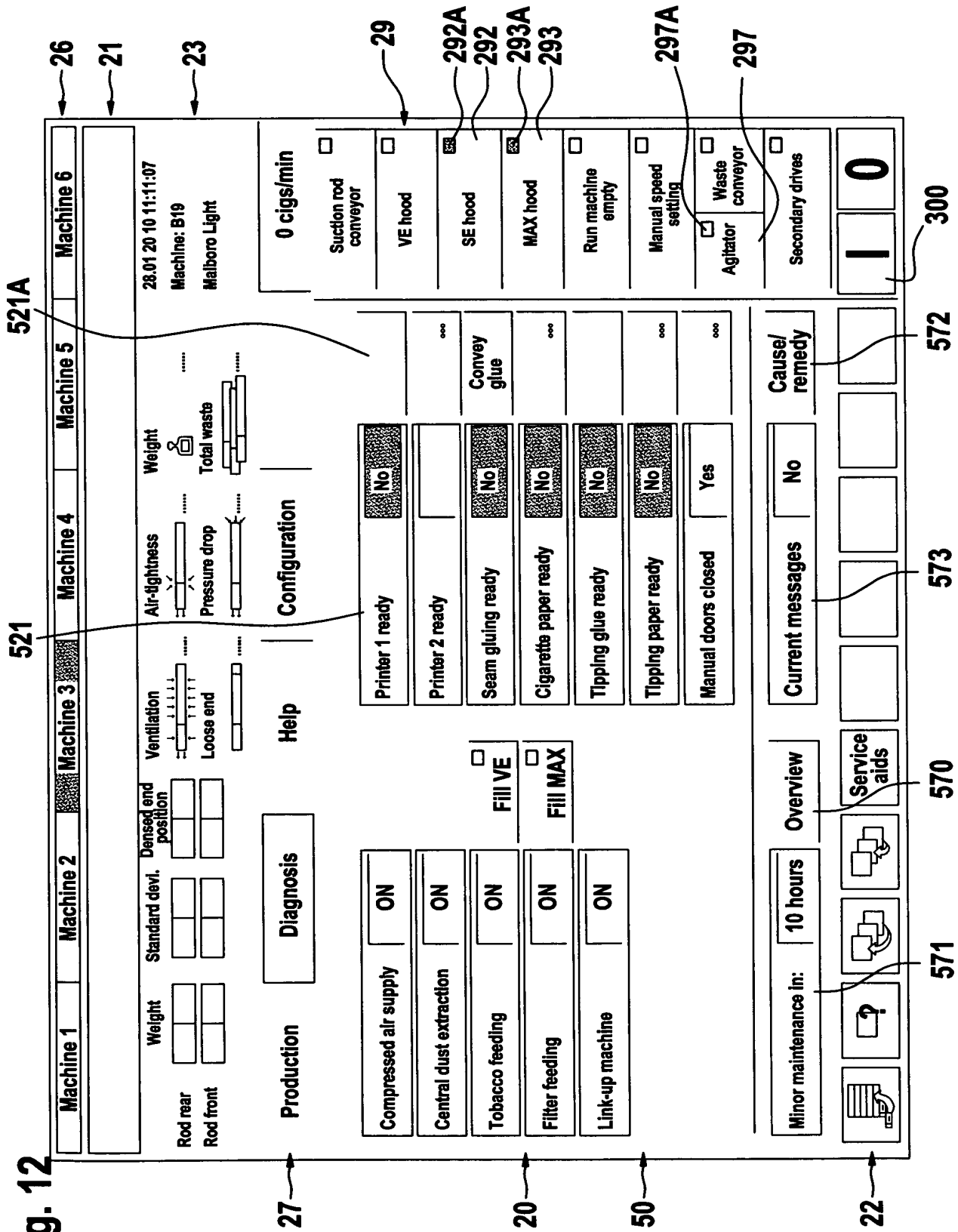


Fig. 13

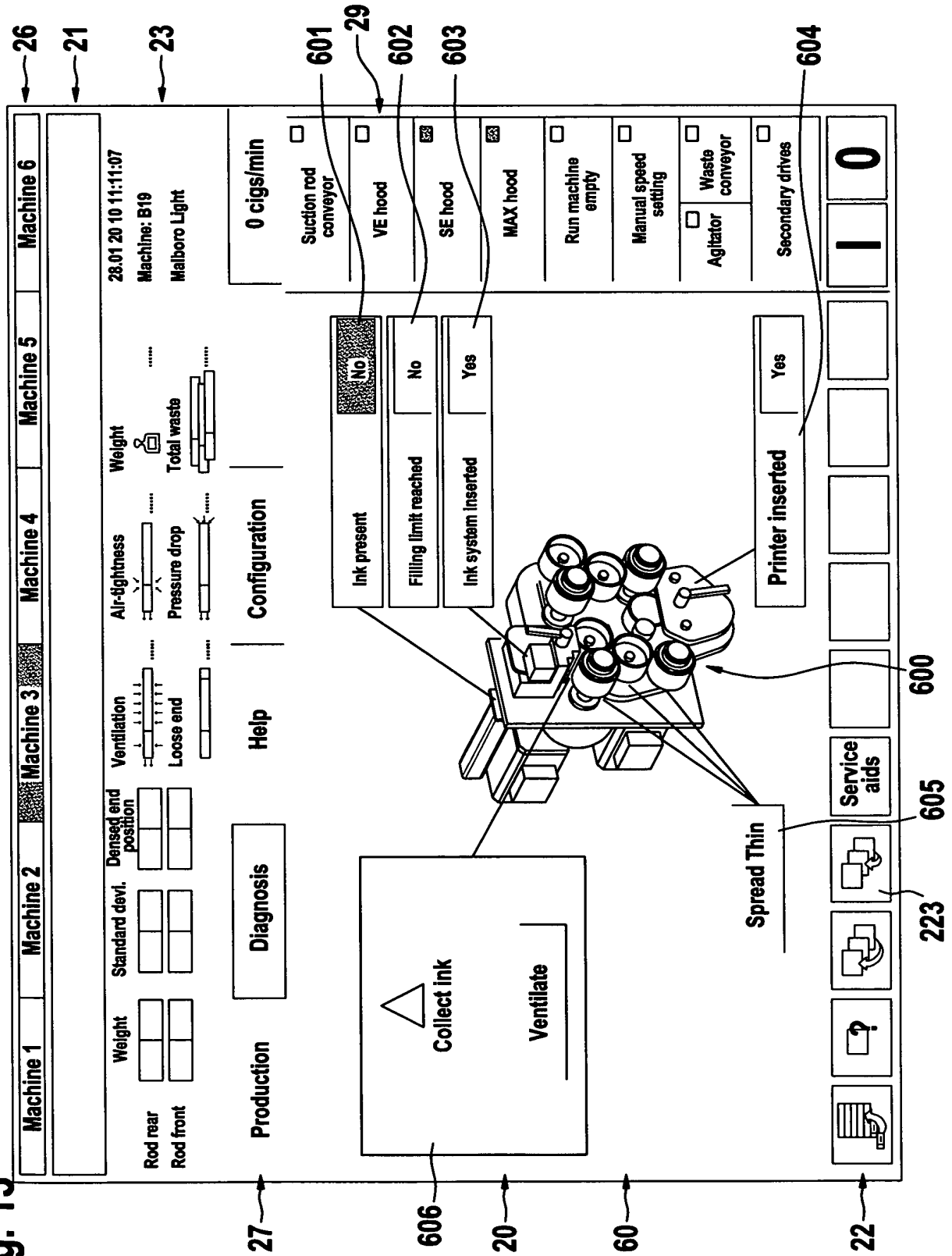


Fig. 14

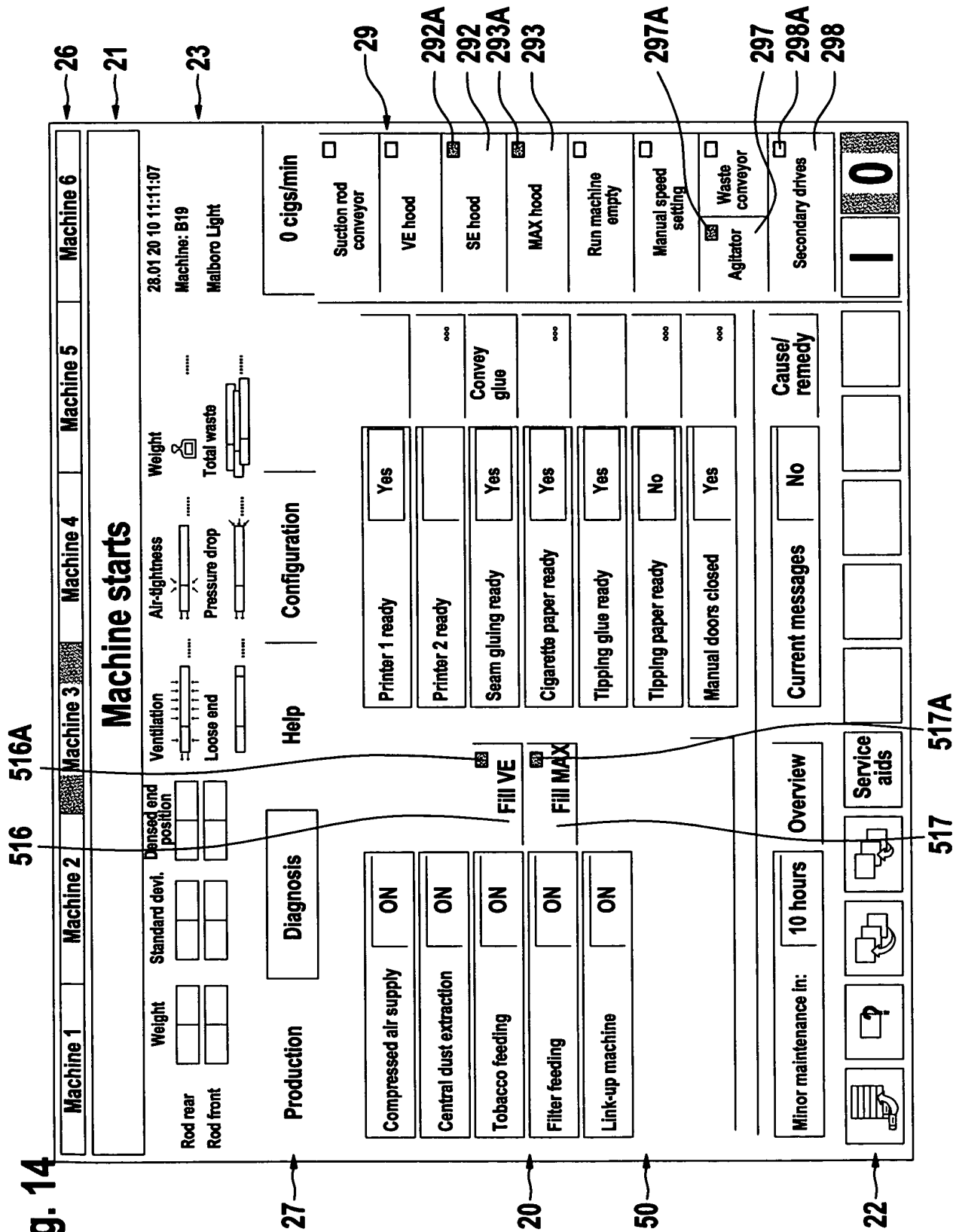


Fig. 15

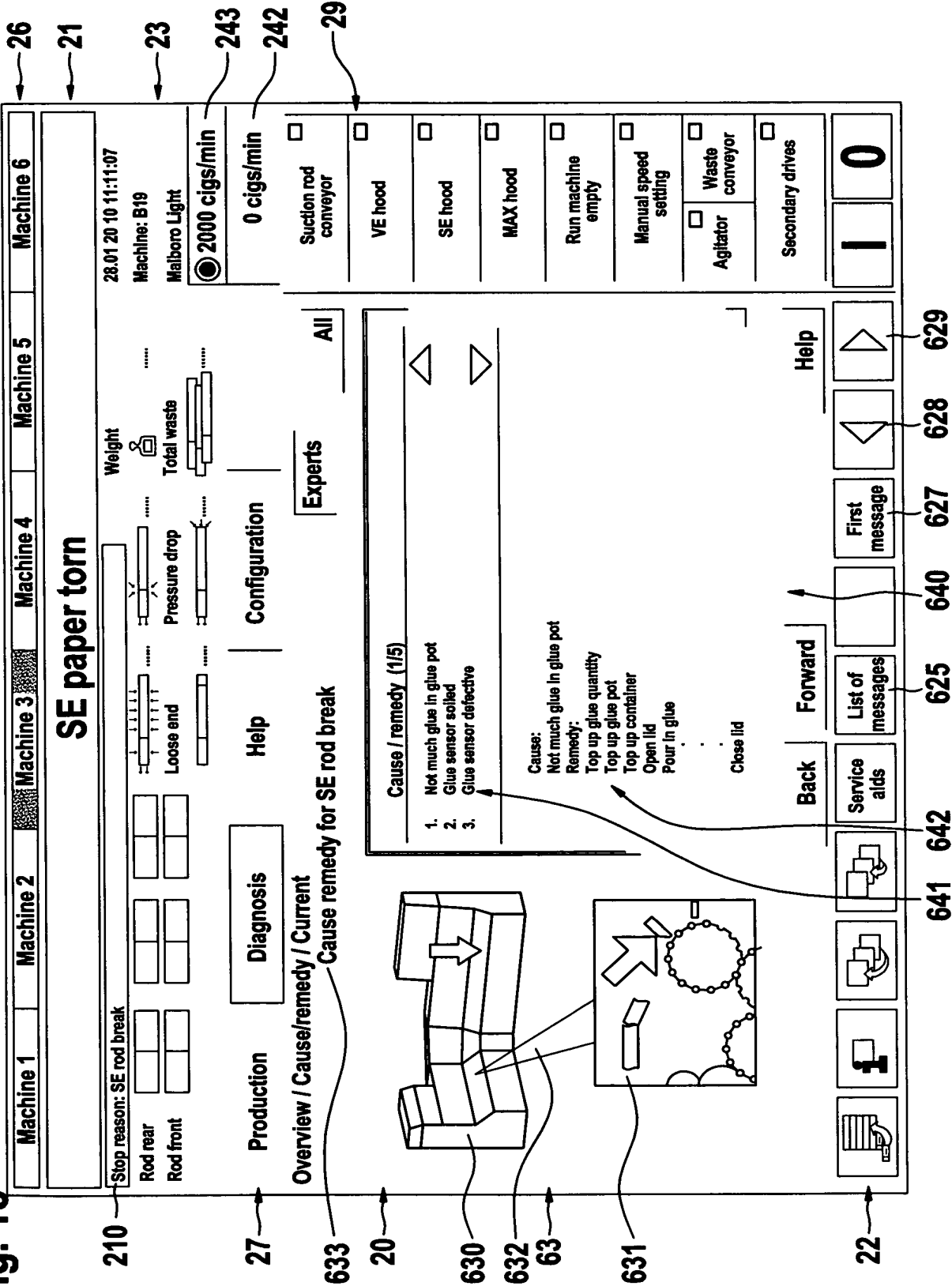


Fig. 16

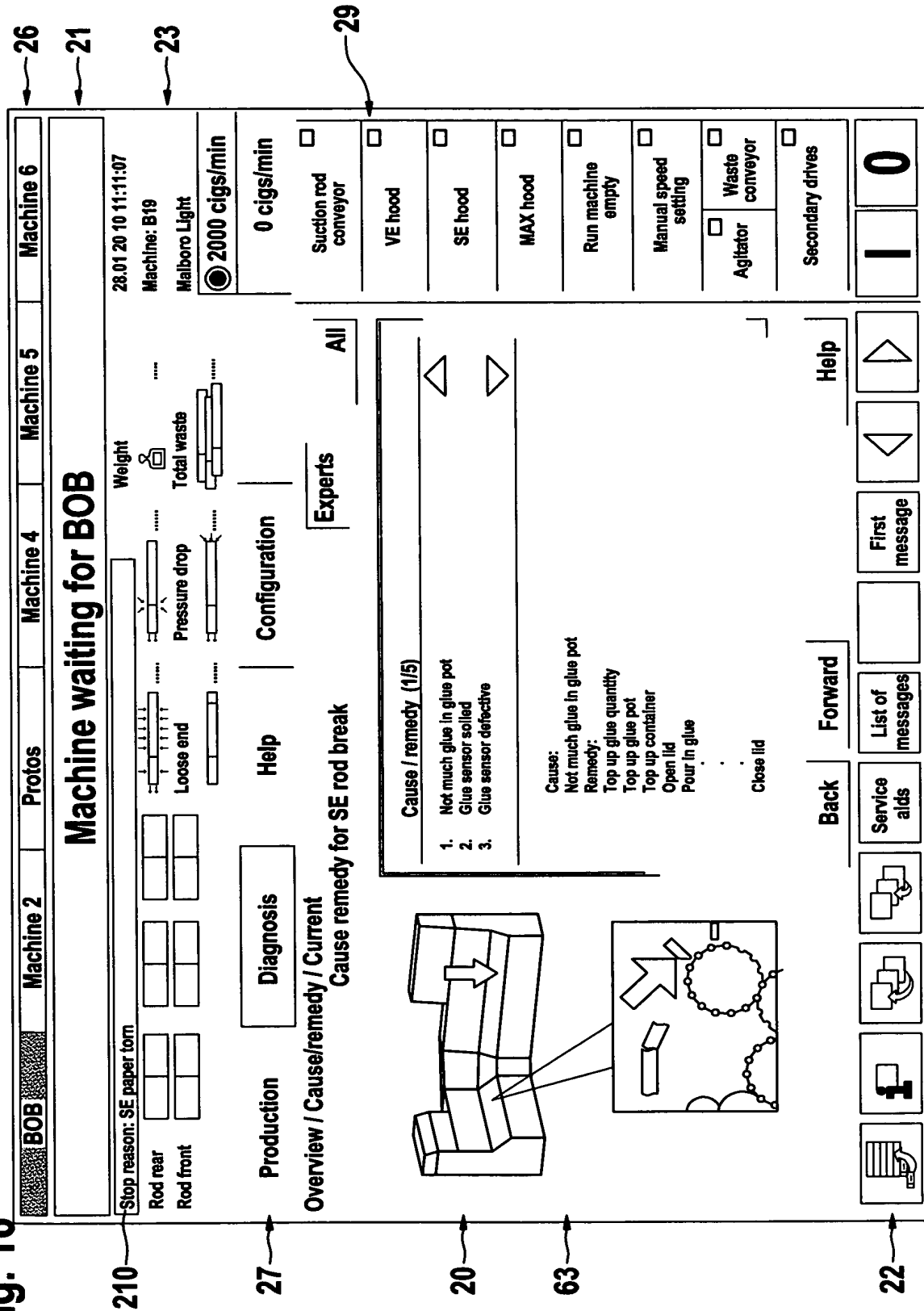


Fig. 17

Machine 1
Machine 2
Machine 3
Machine 4
Machine 5
Machine 6

26
21
23

28.01 20 10 11:11:07
Machine: B19

Machine: B19
Malboro Light

Weight

Rod rear

Rod front

Standard devl.

Densed end position

Ventilation

Loose end

Air-tightness

Pressure drop

Weight

Total waste

Production
Diagnosis
Help
Configuration

Maintenance

Maintenance interval < 75 hours

	hh:mm
Change format belt	00:14 ✓
Change MAX knife	00:30 ✓
Change suction belt	00:56 ✓
Change SE knife	01:08 ✓
Clean VE air lock flap	10:30 ✓
Clean print mark rollers	13:27 ✓

Maintenance interval ≥ 75 hours

	hh:mm
Clean nozzle trough	33:12 ✓
Check filling roller	33:12 ✓
Check beater roller	33:12 ✓
Clean predistributor	33:12 ✓
Check trimmer discs	64:30 ✓
Clean SE grinding unit	64:30 ✓
Clean transfer device	64:30 ✓
Clean dust extraction cyclone	64:30 ✓
Clean VE sieves	64:30 ✓

0 cigs/min

Suction rod conveyor

VE hood

SE hood

MAX hood

Run machine empty

Manual speed setting

Agitator

Waste conveyor

Secondary drives

1 0

27
20
61
22

612
610
613
614
612
611
613
614

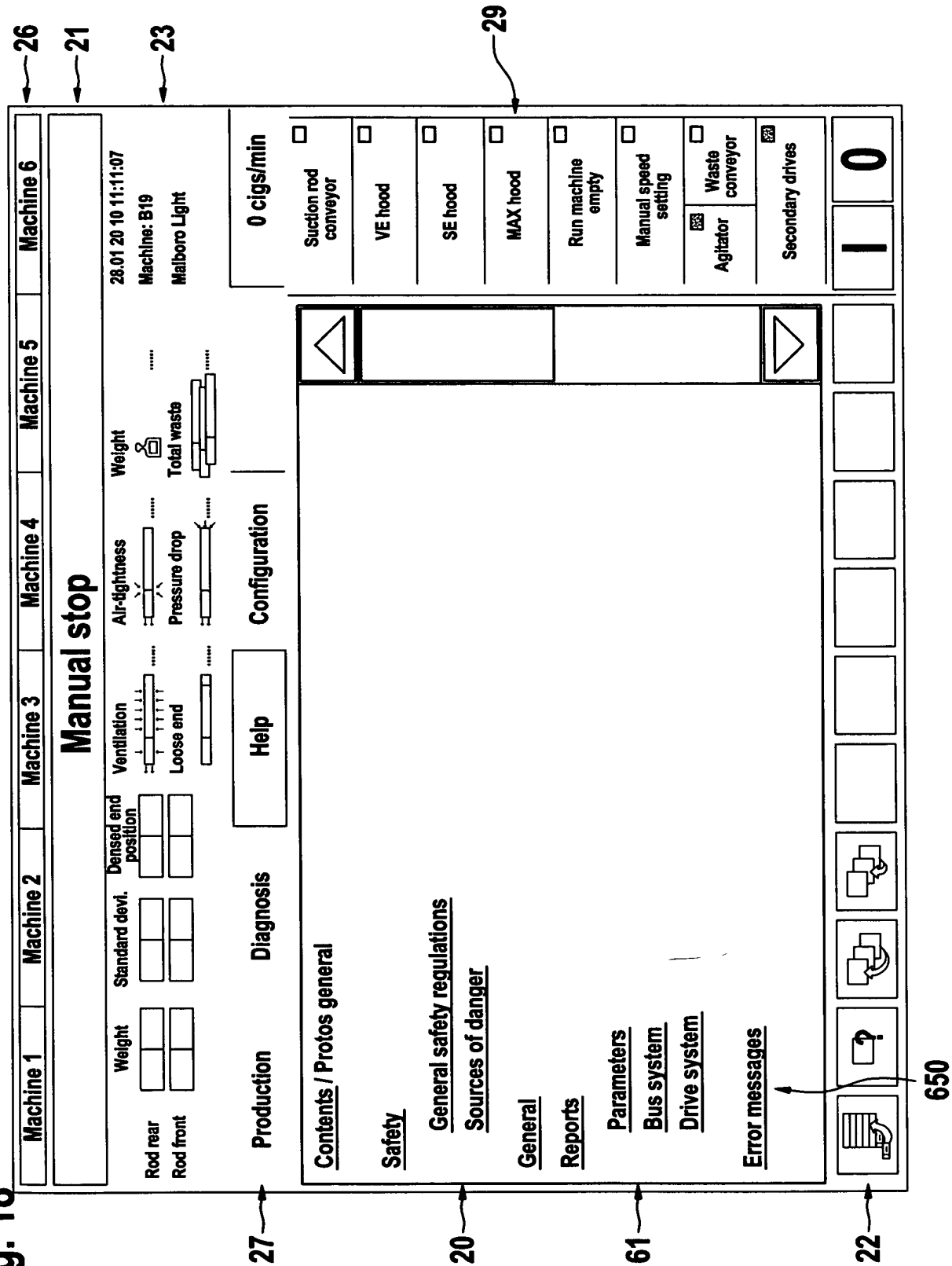


Fig. 19

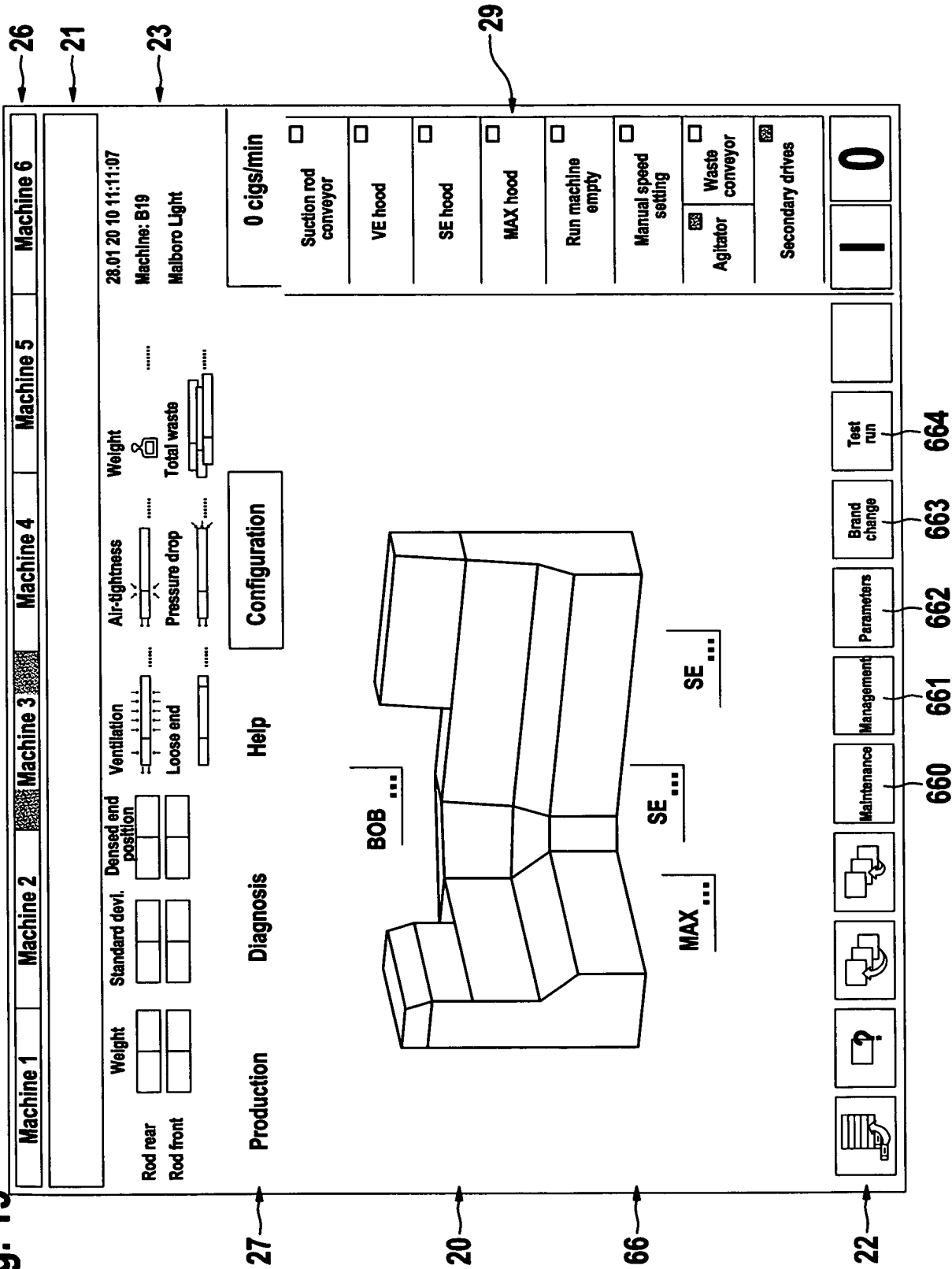
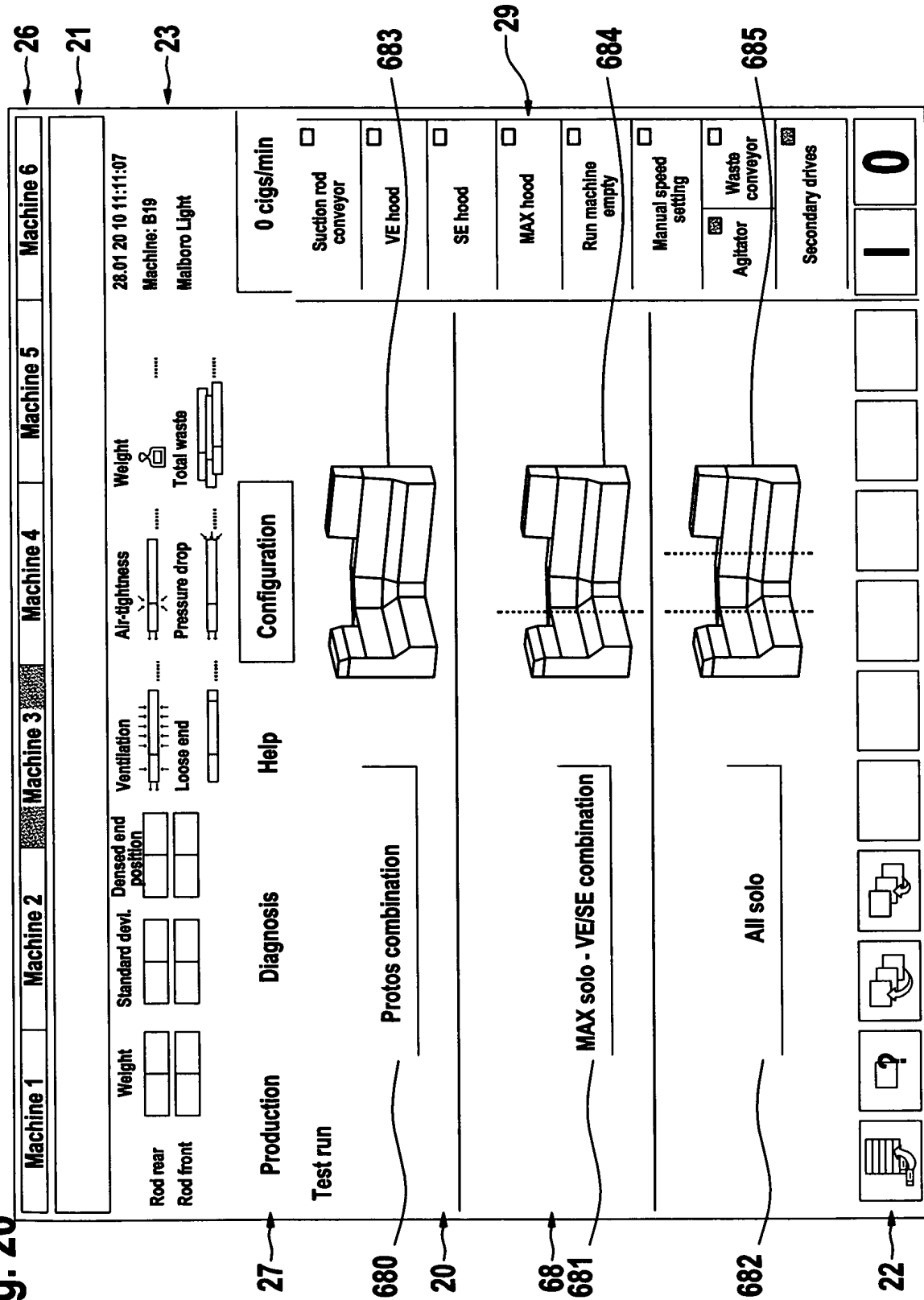


Fig. 20



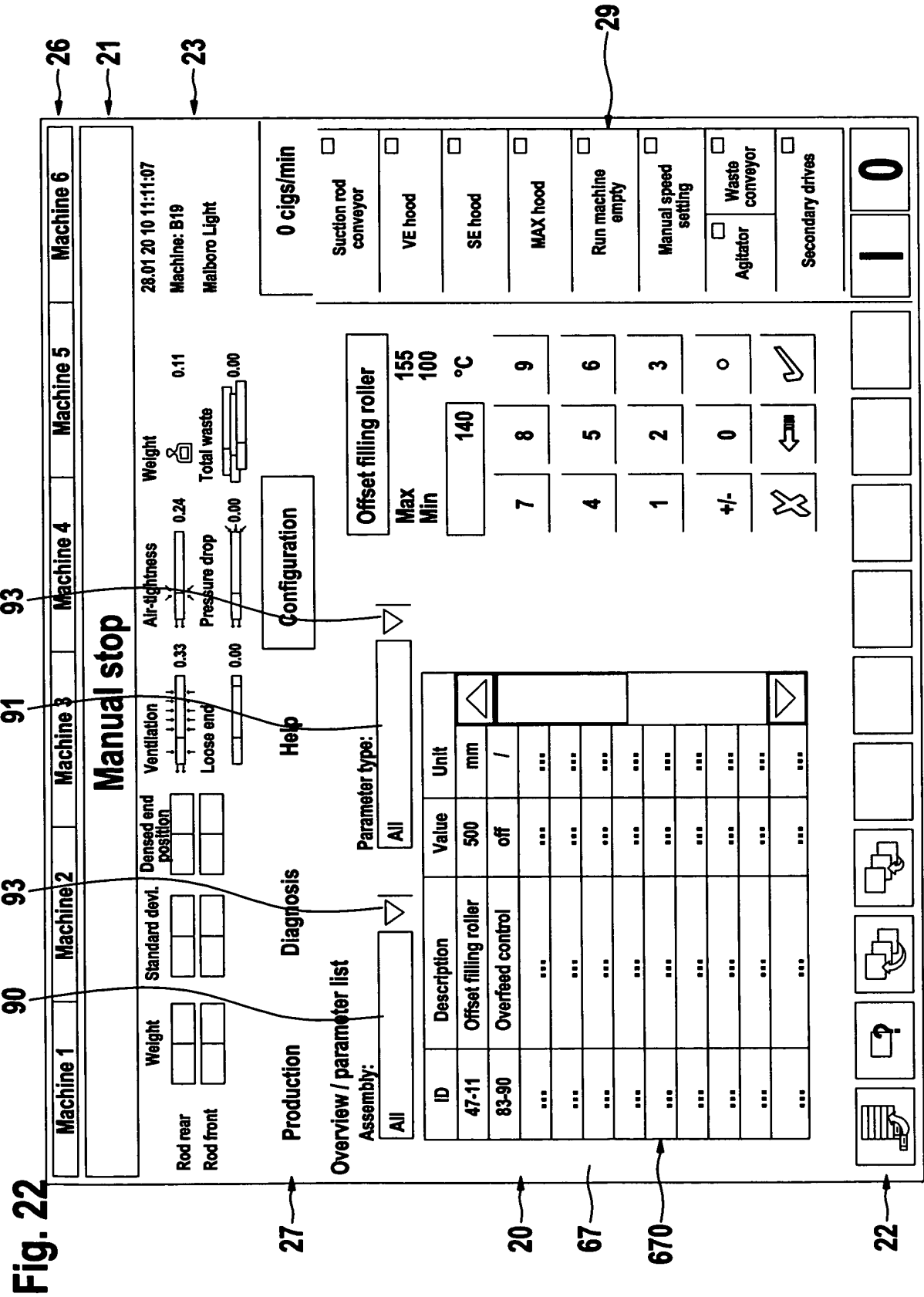


Fig. 23

